

Date: Thursday, 23/04/2009 1:40:05 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GHW MOD KIT
Job Number :	47406		
Estimate Number :	11182		
P.O. Number :		Part Number :	D350615041
This Issue :	23/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-615
First Issue :	/ /	Project Number :	N/A
Previous Run :	45347	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JUL 09.04.23	Due Date :	30/04/2009
Comment :	Est Rev:K Removed Manufacturing 05-12-05 JLM	Qty:	59 60 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

S 09/04/23

2.0	47406A	"T" HANDLE ASSEMBLY
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* Comment: Sub-Component "T" HANDLE ASSEMBLY

1 x D2282-041

Batch

B45347A

EP 09/04/24

3.0	47406B	SADDLE ASSEMBLY
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Comment: Sub-Component SADDLE ASSEMBLY

1 x D2282-043

Batch

45347B

(10x)

B46685

(5x)

EP 09/04/24

4.0	D30153	Locknut
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 180.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 D3015-3

5/16 Locknut

B44461

(67x)

B 45394

(13x)

EP 09/04/24

5.0	D30155	SS Nylock Nut 7/16
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3015-5

7/16 Locknut

B41899

(42)

B45393

(18x)

EP 09/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 51618015C SS Bolt 5/16-18 1.5" L



Ep09/04/24

Comment: Qty.: 3.0000 Each(s)/Unit Total: 180.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

M107762 (674)

M110502 (50)

M111550 (150)

M110438 (490)

7.0 516WC SS Flat Washer 5/16



Ep09/04/24

Comment: Qty.: 12.0000 Each(s)/Unit Total: 720.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

M110138 (1212)

M110726 (600)

8.0 71614050C SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

M110729

Ep09/04/24

9.0 716WC SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref) "T" Handdle Assembly

1 D2282-043 (Ref) Saddle Assembly

M110458

B45347A

B45347B (160)

B46685D (500)

Ep09/04/24

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

Ep09/04/28

(59)

11.0 QCS INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

S09/04/28 (255)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 1:40:05 PM
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Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sorley 29

*x29 sets
+1 in box blue*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location: _____

PPP Rev: _____

Rev E

8809/04/29 C89

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



*MF
09-04-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED BW	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47406



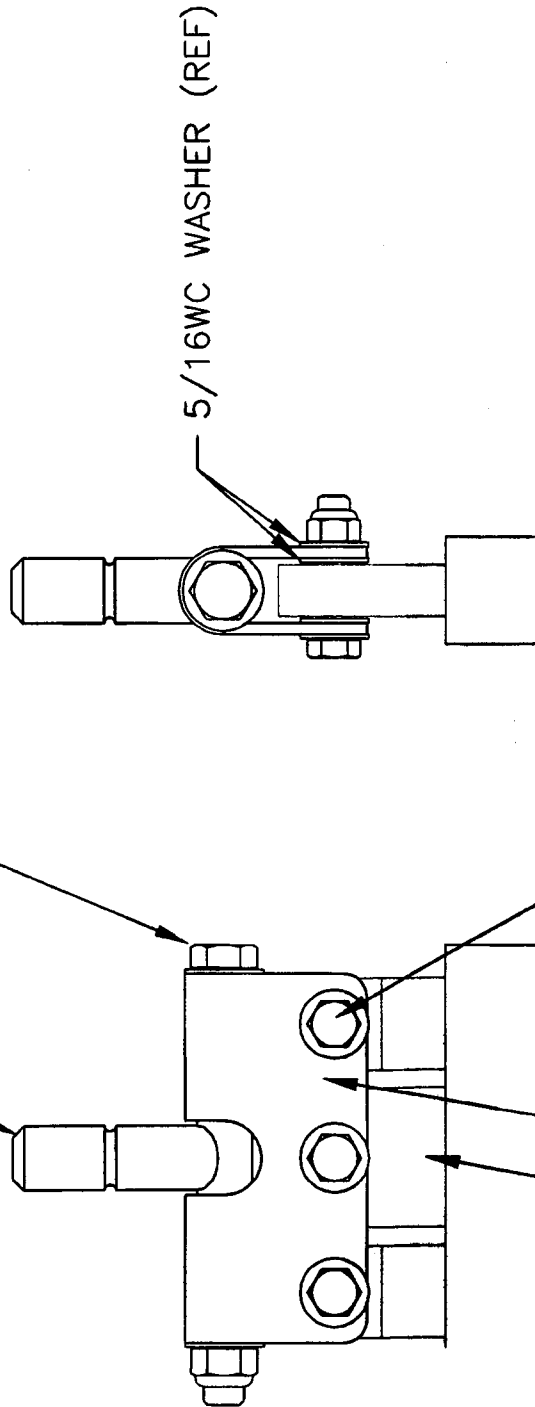
DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED BW	DRAWING NO. D350-615	REV. B SHEET 2 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)



EXISTING PUMP
BODY

D2282-043 SADDLE
ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
57502